



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

order
12925

D2563

Job Sheet 189599



Part No: D2563

Job Qty: 4 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 2/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	2/15/19		0.00	5.88	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		3LH
110	QC 9	4 pcs	2/15/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 24 9-59	Ppc
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	2/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	DAS 24 9-59	Ppc
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

Plex 1/28/19 3:43 PM Dart.Macdonald.Dara

130	Handfinish - 1-1 Chemical- B4B	4 pcs	2/15/19	0.00 1.07	QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	ML 14-02-06
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	QC 7	4 pcs	2/15/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	

150 Large Fab - Welded Assy-2-B4B	4 pcs	2/15/19	0.00 5.88	QC 7 - 60	FEB 06 2019 68 9-89
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
160 QC 10	4 pcs	2/15/19	0.00 0.00	Large Fab - 1 - B4B	ALN 24/2/19
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 38	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	DAS 24 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
175 Handfinish - 2-1 Pressure- B4B	4 pcs	2/15/19	0.00 1.07	Handfinish - 2 - 1 - B4B	DR 19/2/17
				Handfinish - 2 - 2 - B4B	
180 Powdercoat - 1 White GI(A)-B4B	4 pcs	2/15/19	0.00 0.67	Powdercoat - 1 - B4B	BEB 19-02-07
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 Handfinish - 3-1- WingWalk-B4B	4 pcs	2/15/19	0.00 1.07	Handfinish - 3 - 1 - B4B	BEB 19-02-08
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
200 QC 3	4 pcs	2/15/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	

					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	DAS
					QC 3 - 68	FEB 14 2019 68
					QC 3 - 9	9-89
210	Packaging 3-1 - Stock - B4B	4 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS
					Packaging 3 - 2 - B4B	46 FEB 14 2019
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
220	QC 21 - SA	4 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-89 FEB 14 2019
Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Debur ends Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind 110 - (QC9- Inspect visual per QSI004- Fusion Welds) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Chemical Conversion Coat per QSI005 4.1) 140 - (QC7-Inspect Chemical Conversion Coat) 150 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Inspect for foreign object per QSI 024 2-Weld Remainig End cap as per Dwg D2563 using DT 8343 3-Grind 160 - (QC10- Inspect visual per QSI004- ground welds) 170 - (QC5- Inspect part completeness to step on W/O)						

175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005

180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 2:25 TEMP: 300° FINISH: 2:55 M138997.

190 - (Wing Walk as per dwg QSI005 4.4 Batch M138963)

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	B164533
D2561	Lug	8 pcs (2 ea)	100-Large Fab - Welded Assy-1	S149838
D2564	Mounting Angle	8 pcs (2 ea)	100-Large Fab - Welded Assy-1	S124417
D2673-34	End Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	S077409
D2673-34	End Plate	4 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	S149847

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	4	100	0
	D2561	8	2	0
	D2564	8	31	0
	D2673-34	4	4	0
	D2673-34	4	4	0
150-Large Fab - Welded Assy-2- B4B				

Part Specifications

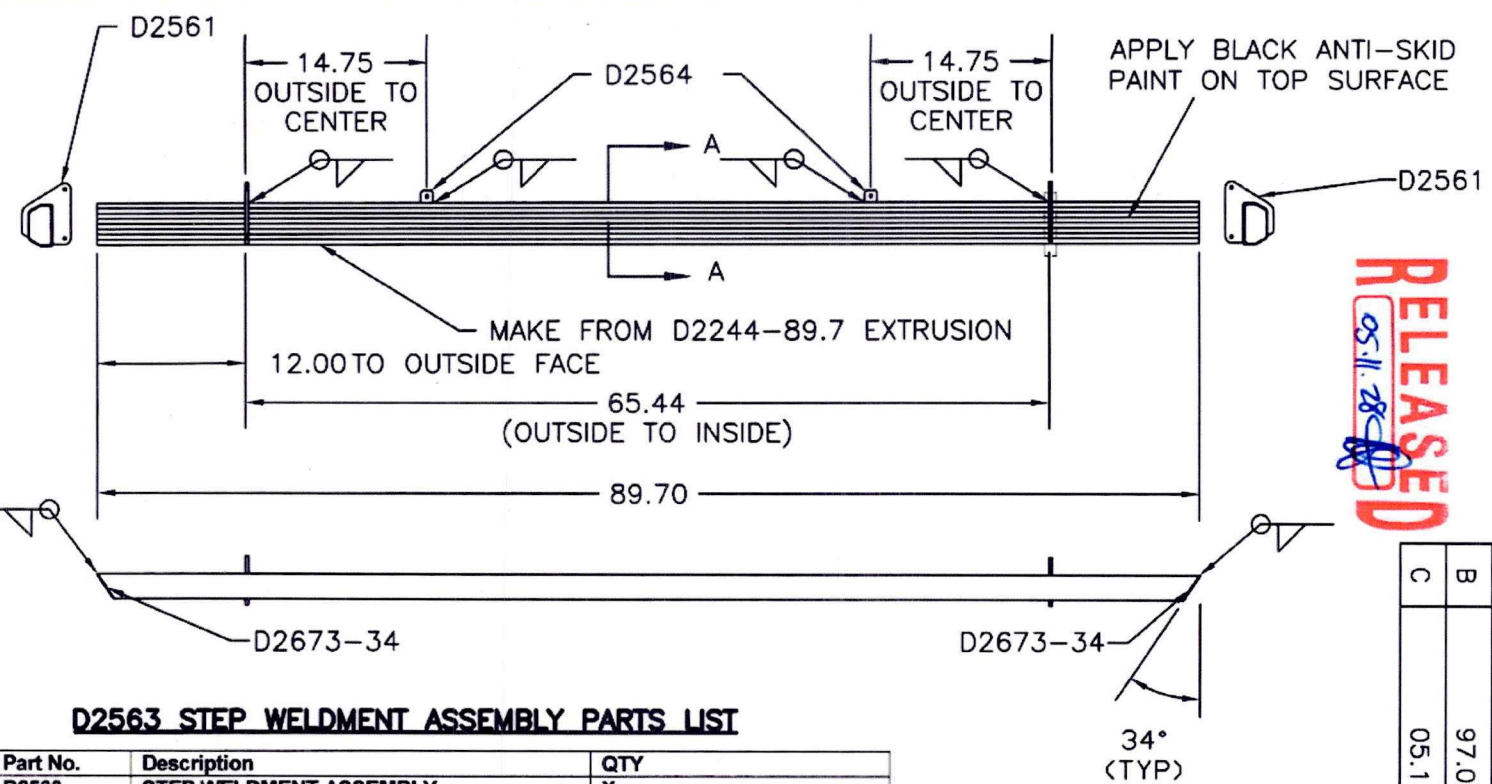
Specifications could not be found.

7925

Plex 1/28/19 3:43 PM Dart.Macdonald.Dara



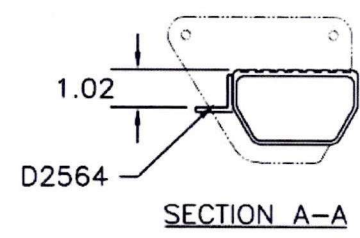
RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY
A	96.04.26	NEW ISSUE	SCALE 1:15
B	97.05.14	END CAPS CHANGED (WAS D2248)	REV. C
C	05.11.14	UPDATE NOTES	SHEET 1 OF 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S150925



Part: D2563

Job No: 189599

Serial No/Batch: S150925

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/05/19